



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3200-20-1

Job Sheet 171143



Part No: RBE350A93-3200-20-1

Job Qty: 6 ea

Part Name: Main Gear Box/Rotor Brake Retaining Nut Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3200-20 REV:D IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Machining-4		
100	CNC Lathe	6 pcs		2/9/18	0.00	8.00	MORI SL-154 NLY 2500		
110	QC	6 pcs		2/9/18	0.00	0.00	QC2 Machining-5		
130	QC	6 pcs		2/9/18	0.00	0.00	QC8 Machining-5		
230	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-2		
240	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		

Part Op 100 - 1-Machine as per folio FB73 FOLIO REV: _____ DWG REV: _____ 2-Broach as per dwg.

Descriptions: 3-Deburr

230 - IDENTIFY AND STOCK

DAS
21
9-50

MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	6 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.000	6	16	0

Part Specifications

Specifications could not be found.

Plex 1/29/18 2:09 PM Dart.lajeunesse.marie



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CANADA
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Container No: S046621



Part: RBE350A93-3200-20-1

Job No: 171143

Serial No/Batch: S046621

Revision: D

Inspector:

RBES50A93-3200-20-1

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



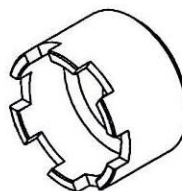
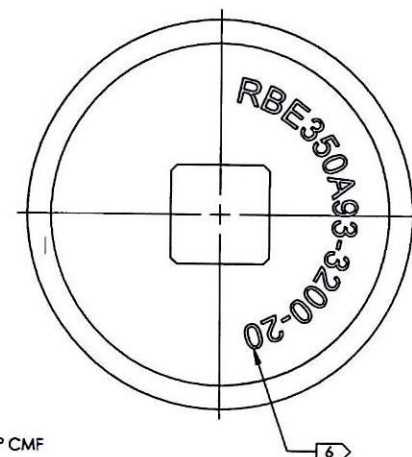
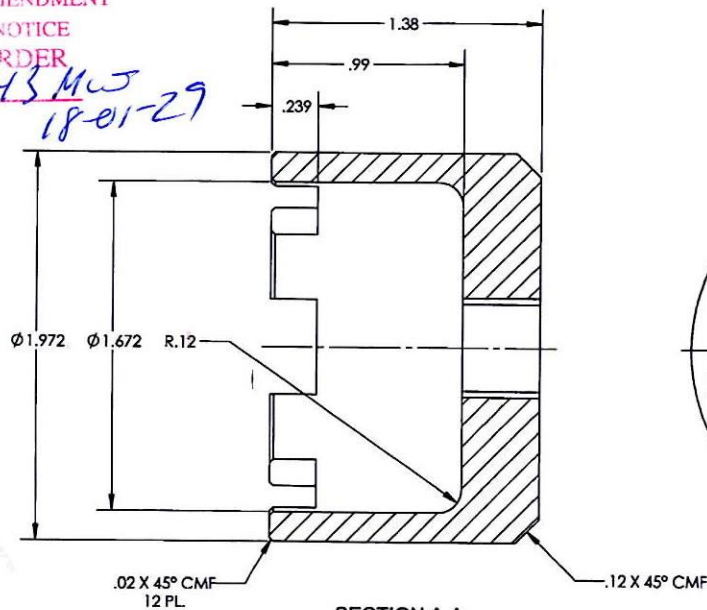
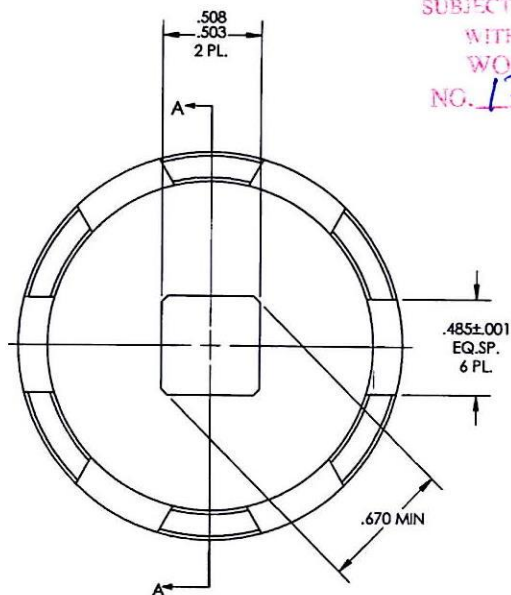
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
D	DIMENSION .505 CHANGED FOR .503/.508, TEMPLATE UPDATED, DIMENSION .985 CHANGED FOR .99, CHAMFER .02 X 45° 12 PL. ADDED, ENGRAVING CHANGED FOR MACHINE ENGRAVE, DIMENSION .670 MIN ADDED, DIMENSION .485 CHANGED FOR .485 +/- .001 EQ.SP. 6 PL., DIMENSION 60° (x6) REMOVED	17-799	17.12.21	VM	ML

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171143 MJS
18-01-29



- NOTES:
- 1) MATERIAL: 17-4 PH-H900 SS
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 X 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, 0.010" DEEP

RBE350A93-3200-20-1 MGB/ROTOR BRAKE RETAINING NUT WRENCH

DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE MGB/ROTOR BRAKE RETAINING NUT WRENCH			
PART NO. RBE350A93-3200-20		REV D	
TOOL NO. RBE350A93-3200-20		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 17/12/21	INITIALS AND DATE	TOLERANCES: XXX ± .005 XX ± .01 X ± .1	FRACTIONS: 1/8 ANGLES: 1/4° SURFACE: RA ROUGHNESS
DRAWN BY: VM 12/21/2017			
CHECKED BY: VM 01/02/2018			
MFG REVIEW BY: DD 01/02/2018			
APPROVED BY: ML 01/04/2018		SCALE: NTS	SHEET 2 OF 5
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M. Lee